COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

CONTROL STAND FLAP CONTROL HANDLE ASSEMBLY

PART NUMBER 254A1260–1, –2

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COMPONENT MAINTENANCE MANUAL

Revision No. 6
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To: All holders of CONTROL STAND FLAP CONTROL HANDLE ASSEMBLY 27-09-44.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

The COMPONENT MAINTENANCE MANUAL is furnished either as a printed manual, on microfilm, or digital products, or any combination of the three. This revision replaces all previous microfilm cartridges or digital products. All microfilm and digital products are reissued with all obsolete data deleted and all updated pages added.

For printed manuals, changes are indicated on the List of Effective Pages (LEP). The pages which are revised will be identified on the LEP by an R (Revised), A (Added), O (Overflow, i.e. changes to the document structure and/or page layout), or D (Deleted). Each page in the LEP is identified by Chapter-Section-Subject number, page number and page date.

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Location of Change	Description of Change
	NO HIGHLIGHTS

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COMPONENT MAINTENANCE MANUAL

A = Added, R = Revised, D = Deleted, O = Overflow

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL

COMPONENT MAINTENANCE MANUAL

All revisions to this manual will be accompanied by transmittal sheet bearing the revision number. Enter the revision number in numerical order, together with the revision date, the date filed and the initials of the person filing.

Revision		Filed		Revision		Filed	
Number	Date	Date	Initials	Number	Date	Date	Initials

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Temporary Revision		Inserted		Removed	
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Temporary Revision		Inserted		Removed	
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INTRODUCTION

1. General

A. The instructions in this manual supply the data necessary to do the maintenance functions together with the test, fault isolation, repair, and replacement of the defective parts.

B. This manual is divided into different parts:

(1) Title Page

(2) Transmittal Letter

(3) Highlights

(4) List of Effective Pages

(5) Table of Contents

(6) Temporary Revision & Service Bulletin Record

(7) Record of Revisions

(8) Record of Temporary Revisions

(9) Introduction

(10) Procedures & IPL Sections

C. Components that can be repaired have a different repair number for each specified repair. To find the repair number location of a component, look in the Repair-General procedure at the beginning of the REPAIR section. The Repair-General procedure also has an explanation of the True Position Dimension symbols used.

D. All dimensions, measures, quantities and weights included are in English units. When metric equivalents are given they will be in the parentheses that follow the English units.

E. The introduction to the Illustrated Parts List (IPL) shows how the IPL data is used.

F. Design changes, optional parts, configuration differences and Service Bulletin modifications may cause different part numbers. These part numbers are identified in the IPL with an alphabetical letter which is added to the end of the basic item number. This new item number is referred to as an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless shown differently.

G. The tool reference numbers found in the individual procedures and in the Special Tools, Fixtures, and Equipment section are used to identify if a tool is a standard tool (STD-XXXX), a commercial tool (COM-XXXX), or a Special Tool (SPL-XXXX). This reference number is also used to distinguish between tools with similar names in the same procedure. These reference numbers are for use in the documentation only. They are not to be used for ordering tools.

CONTROL STAND FLAP CONTROL HANDLE ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The control stand flap control handle assembly has a handle assembly, a lever, a drum assembly, a link assembly, and a cable assembly.

2. Operation

A. When the pilot pulls up on the flap control handle assembly while it is installed in the airplane, the lever detent lug is released from the flap detent on the control stand assembly. This allows the pilot to move the handle assembly to change the position of the flaps. When the pilot lets go of the flap control handle, the spring makes the lever detent lug engage a flap detent position on the control stand assembly.

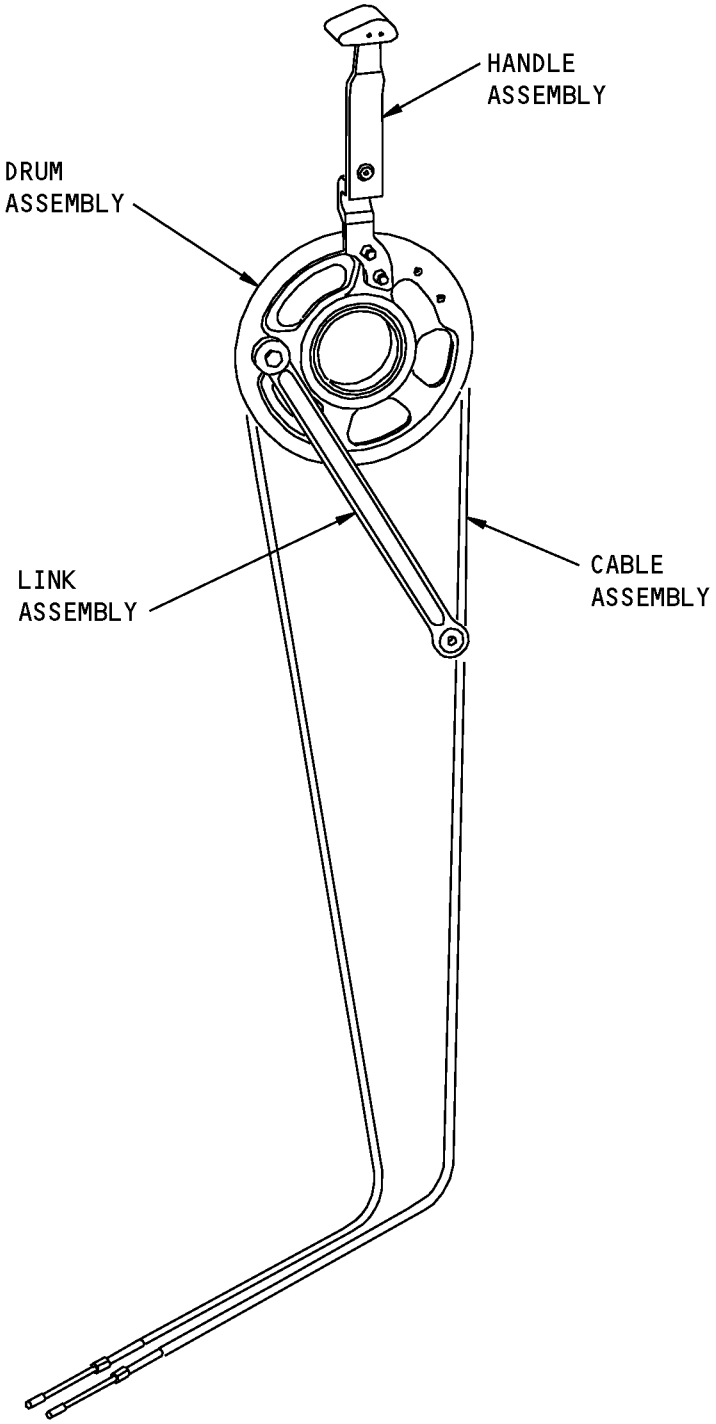
3. Leading Particulars (Approximate)

A. Length – 17.3 inches

B. Width – 6.0 inches

C. Height – 1.8 inches

D. Weight – 1.5 pounds



Control Stand Flap Control Handle Assembly
Figure 1

(NOT APPLICABLE)

DISASSEMBLY

1. General

A. This procedure has the data necessary to disassemble the flap control handle assembly (1A).

B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.

C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

2. Disassembly

A. Part Replacement

NOTE: The parts which follow are recommended for replacement. Unless a procedure tells you to replace a part, replacement is optional.

(1) Spring (115)

B. Disassembly procedure

(1) Use standard industry procedures and the following steps to disassemble this component.

(2) Remove the cable assembly (75) from the flap control handle assembly (1A, 5).

(3) Remove the pins (100, 120), then remove the knob (130), handle (125), stop (110), and spring (115) from the flap control handle assembly (1A, 5).

(4) Remove the bolts (40, 45), then remove the lever (105) from the drum assembly (55).

(5) Remove the bolt (5), washers (10, 15), and nut (20), then remove the link assembly (25) from the drum assembly (55).

CLEANING

1. General

A. This procedure has the data necessary to clean the flap control handle assembly (1A).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to IPL Figure 1 for item numbers.

2. Cleaning

A. References

Reference	Title
SOPM 20-30-01	CLEANING AND RELUBRICATING BEARINGS
SOPM 20-30-03	GENERAL CLEANING PROCEDURES

B. Cleaning procedures

(1) Clean the bearings (30, 65) as specified in SOPM 20-30-01.

(2) Clean all the parts, other than the bearings (30, 65), as specified by standard industry practices (SOPM 20-30-03).

CHECK

1. General

A. This procedure has the data necessary to find defects in the material of the specified parts.

B. Refer to FITS AND CLEARANCES for the design dimension and wear limits.

C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

2. Check

A. References

Reference	Title
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

B. Procedure

(1) Use standard industry procedures to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible damage or if you suspect possible damage on the parts listed below:

(2) Do a magnetic particle check (SOPM 20-20-01) of these parts:

(a) Lever (105)

(b) Stop (110)

(3) Do a penetrant check (SOPM 20-20-02) of these parts:

(a) Drum (70)

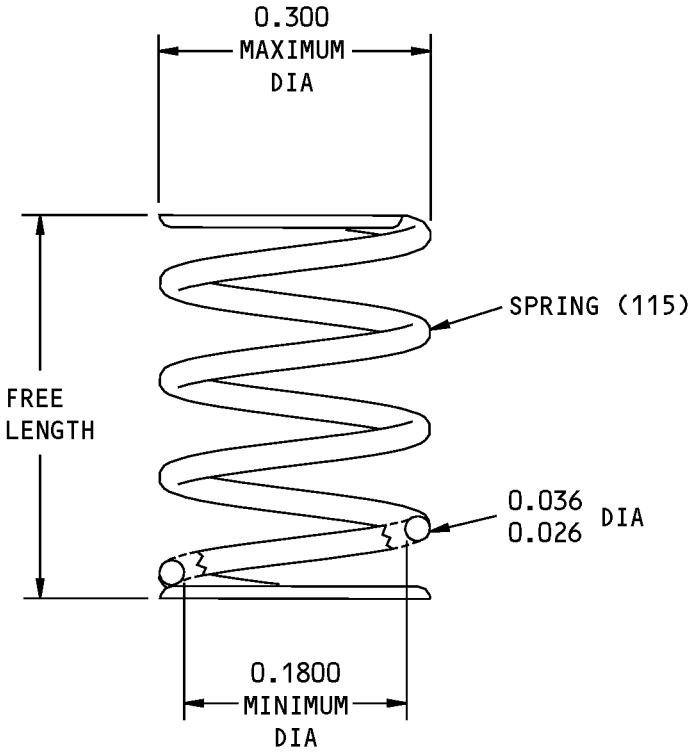
(b) Handle (125)

(4) Do a check of the spring (115) as shown in CHECK, Figure 501.

(a) Make sure the spring measures approximately 2.0 inches in the free position.

(b) Make sure the spring exerts 4.70-5.70 pounds of force when you compress it to 0.75 inches in length.

(c) Make sure the spring exerts 3.10-3.90 pounds of force when you compress it to 1.16 inches in length.



ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Spring Check
Figure 501

REPAIR

1. General

A. Instructions for repair, refinish, and replacement of the specified subassembly parts are included in each REPAIR when applicable:

Table 601:

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
254A1261	DRUM ASSEMBLY	2-1, 2-2
254A1264	LINK ASSEMBLY	3-1, 3-2
65-32189	HANDLE	4-1

2. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in the applicable repair procedures are shown in REPAIR-GENERAL, Figure 601.

—	STRAIGHTNESS
▱	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⌭	CYLINDRICITY
⌒	PROFILE OF A LINE
⌓	PROFILE OF A SURFACE
◎	CONCENTRICITY
=	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
↗↗	TOTAL RUNOUT
⌴	COUNTERBORE OR SPOTFACE
∨	COUNTERSINK
⌖	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
∅	DIAMETER
S ∅	SPHERICAL DIAMETER
R	RADIUS
SR	SPHERICAL RADIUS
()	REFERENCE
BASIC (BSC) OR [DIM]	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE. FROM THIS FEATURE PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
[-A-]	DATUM
Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
Ⓛ	LEAST MATERIAL CONDITION (LMC)
Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
Ⓟ	PROJECTED TOLERANCE ZONE
FIM	FULL INDICATOR MOVEMENT

EXAMPLES

— | 0.002	STRAIGHT WITHIN 0.002
⊥ | 0.002 | B	PERPENDICULAR TO DATUM B WITHIN 0.002
// | 0.002 | A	PARALLEL TO DATUM A WITHIN 0.002
○ | 0.002	ROUND WITHIN 0.002
⌭ | 0.010	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER
⌒ | 0.006 | A	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM A
⌓ | 0.020 | A	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.020 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
◎ | ∅ 0.0005 | C	CONCENTRIC TO DATUM C WITHIN 0.0005 DIAMETER
= | 0.010 | A	SYMMETRICAL WITH DATUM A WITHIN 0.010
∠ | 0.005 | A	ANGULAR TOLERANCE 0.005 WITH DATUM A
⌖ | ∅ 0.002 Ⓢ | B	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
⊥ | ∅ 0.010 Ⓜ | A 0.510 Ⓟ	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010 INCH DIAMETER, PERPENDICULAR TO DATUM A, AND EXTENDING 0.510 INCH ABOVE DATUM A, MAXIMUM MATERIAL CONDITION
[2.000] OR 2.000 BSC	THEORETICALLY EXACT DIMENSION IS 2.000

True Position Dimensioning Symbols
Figure 601

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

A. This procedure has the data necessary to refinish the parts which are not given in the specified repairs.

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to IPL Figure 1 for item numbers.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Instructions for the repair of the parts listed in REPAIR 1-1, Table 601 is for repair of the initial finish.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Lever (105)	15-5PH CRES 150-170ksi	Passivate (F-17.25) and apply lubricant, D00113 (F-19.10) all over.
Stop (110)	8630 or 4130 steel	Cadmium plate (F-15.02)

DRUM ASSEMBLY - REPAIR 2-1

254A1261–3

1. General

A. This procedure has the data necessary to repair the drum assembly (55).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 1 for item numbers.

2. Repair procedures

NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03.

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS

C. Insert Replacement

(1) Remove the inserts (60) from the drum (70).

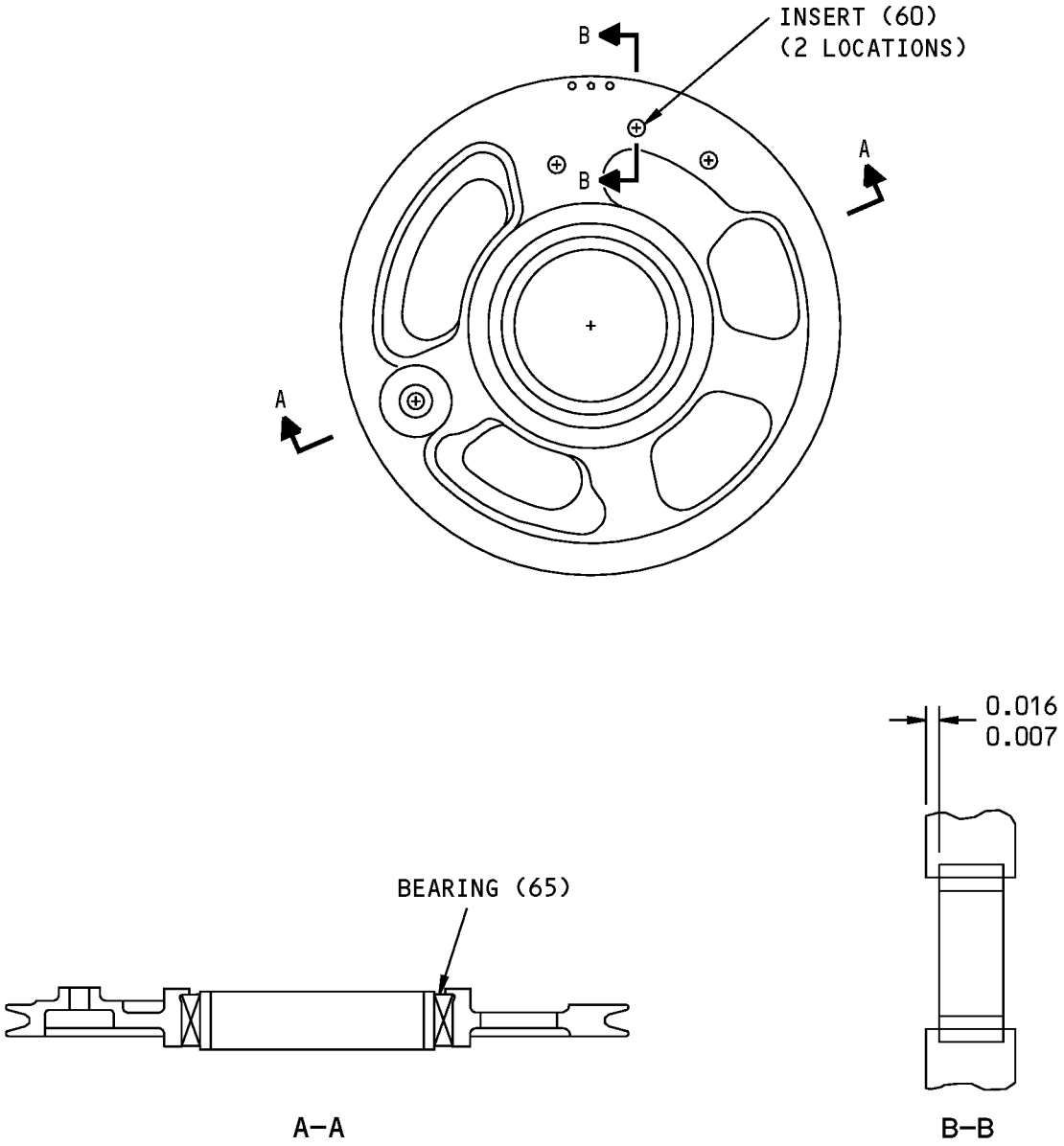
(2) Install new inserts (60) into the drum (70) with primer, C00259 (F-20.02). Make sure the edges of the inserts (60) are 0.007-0.016 inches below the surface of the drum (70) as shown in REPAIR 2-1, Figure 601.

D. Bearing Replacement

(1) Remove the bearing (65) from the drum (70).

(2) Install new bearing (65) into the drum (70) with grease, D00013.

(3) Roller swage the drum (70) over the bearing (65) as specified in SOPM 20-50-03.



ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

254A1261-3 Drum Assembly Repair
Figure 601

DRUM - REPAIR 2-2

254A1261–4

1. General

A. This procedure has the data necessary to repair and refinish the drum (70).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to the REPAIR-GENERAL for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Drum Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

B. References

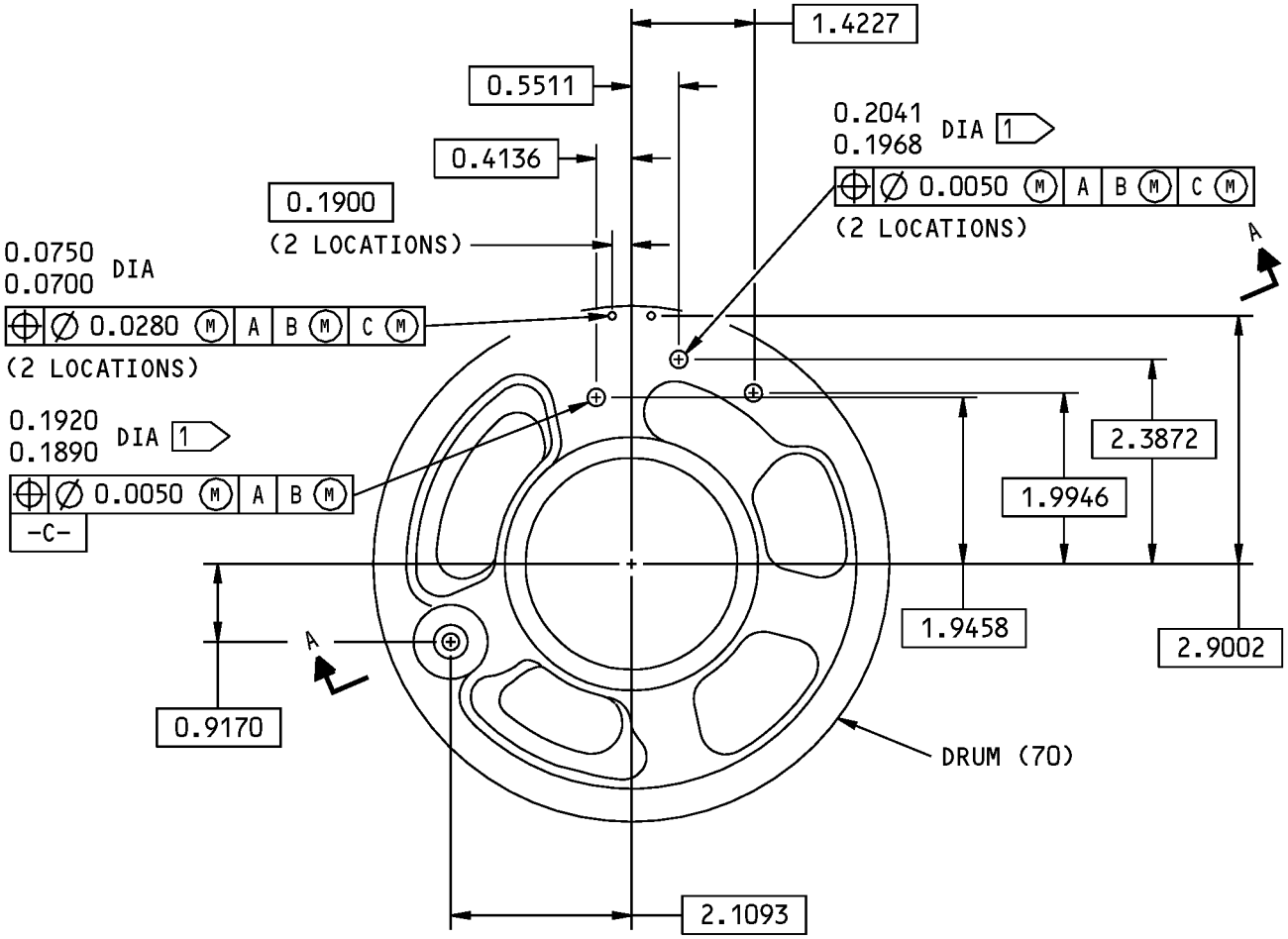
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure

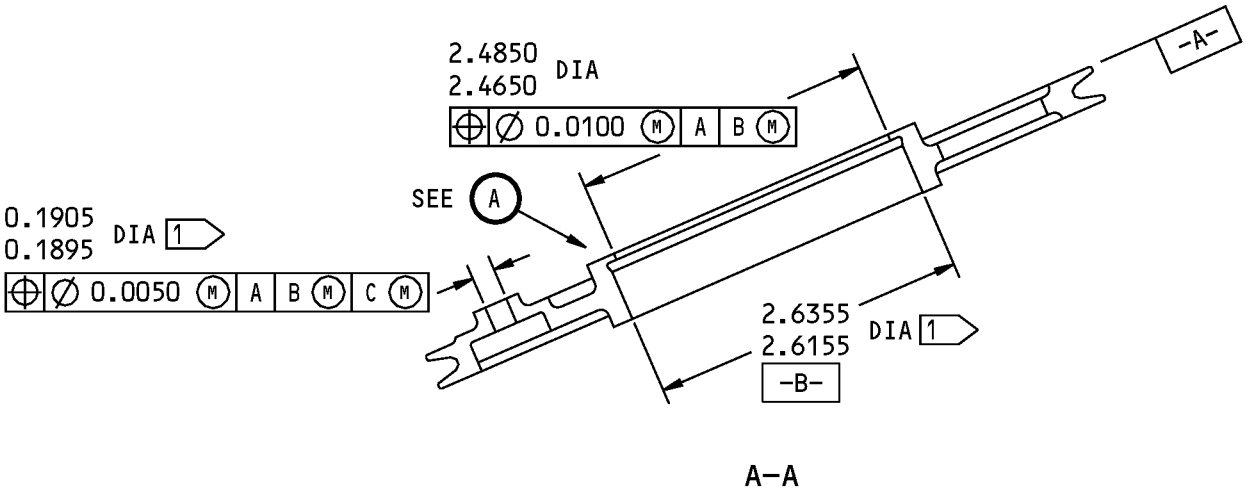
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Remove the old finish from the drum (70).

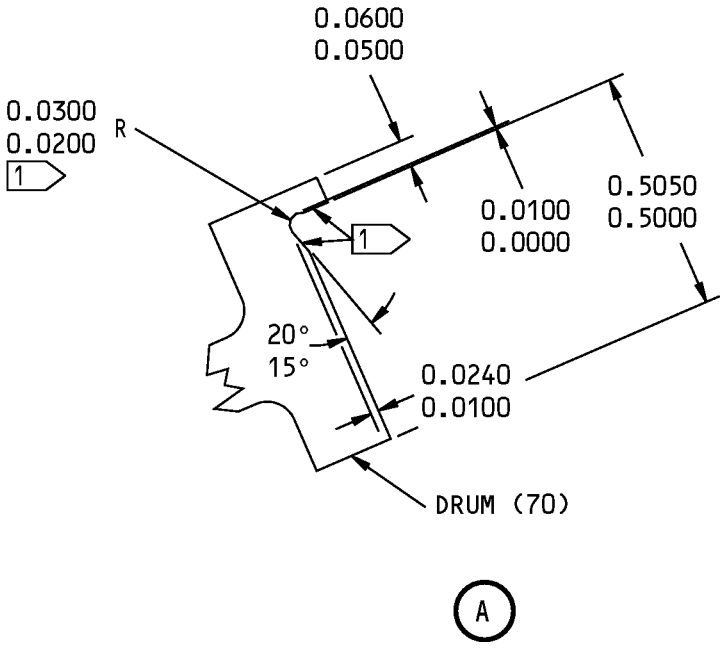
(2) Anodize (F-17.31) and apply primer, C00259 (F-20.02) to the drum (70), except as shown in REPAIR 2-2, Figure 601.



254A1261-4 Drum Repair
Figure 601 (Sheet 1 of 2)



A–A



A

1 DO NOT APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

254A1261-4 Drum Repair
Figure 601 (Sheet 2 of 2)

LINK ASSEMBLY - REPAIR 3-1

254A1264–1

1. General

A. This procedure has the data necessary to repair the link assembly (25).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to the REPAIR-GENERAL for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 1 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

C. Procedure

NOTE: For lubricants, refer to SOPM 20-60-03.

(1) Remove the bearings (30) from the link (35).

(2) Install new bearings (30) into the link (35) with grease, D00013.

(3) Roller swage the link (35) over the bearings (30) on both sides as specified in SOPM 20-50-03.

LINK - REPAIR 3-2

254A1264–2

1. General

A. This procedure has the data necessary to repair and refinish the link (35).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to the REPAIR-GENERAL for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Link Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

B. References

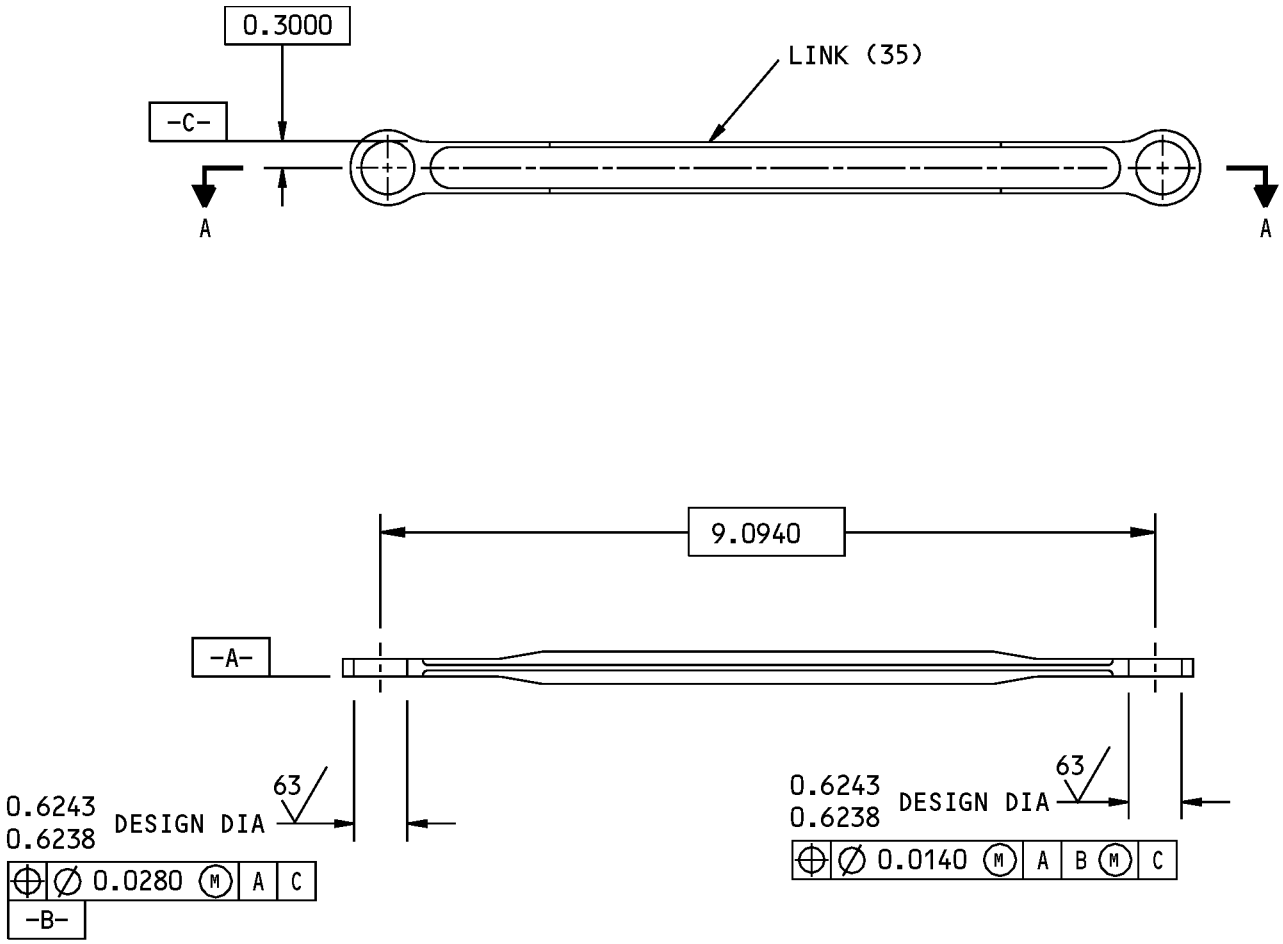
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Remove the old finish from the link (35).

(2) Anodize (F-17.31) and apply primer, C00259 (F-20.02) to the link (35), except do not apply primer, C00259 to the holes.



A–A

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

254A1264-2 Link Repair
Figure 601

HANDLE - REPAIR 4-1

65-32189–13

1. General

A. This procedure has the data necessary to refinish the handle (125).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to the REPAIR-GENERAL for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: 17-4PH Cres

(2) Shot peen: The detent lug surfaces, Intensity 0.008-0.013A, Coverage 2.0

2. Handle Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII
G00167	Coating - Flame Spray Tungsten Carbide Powder	BMS10-67, Type I

B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For shotpeening, refer to SOPM 20-10-03.

(1) Remove the old finish from the handle (125).

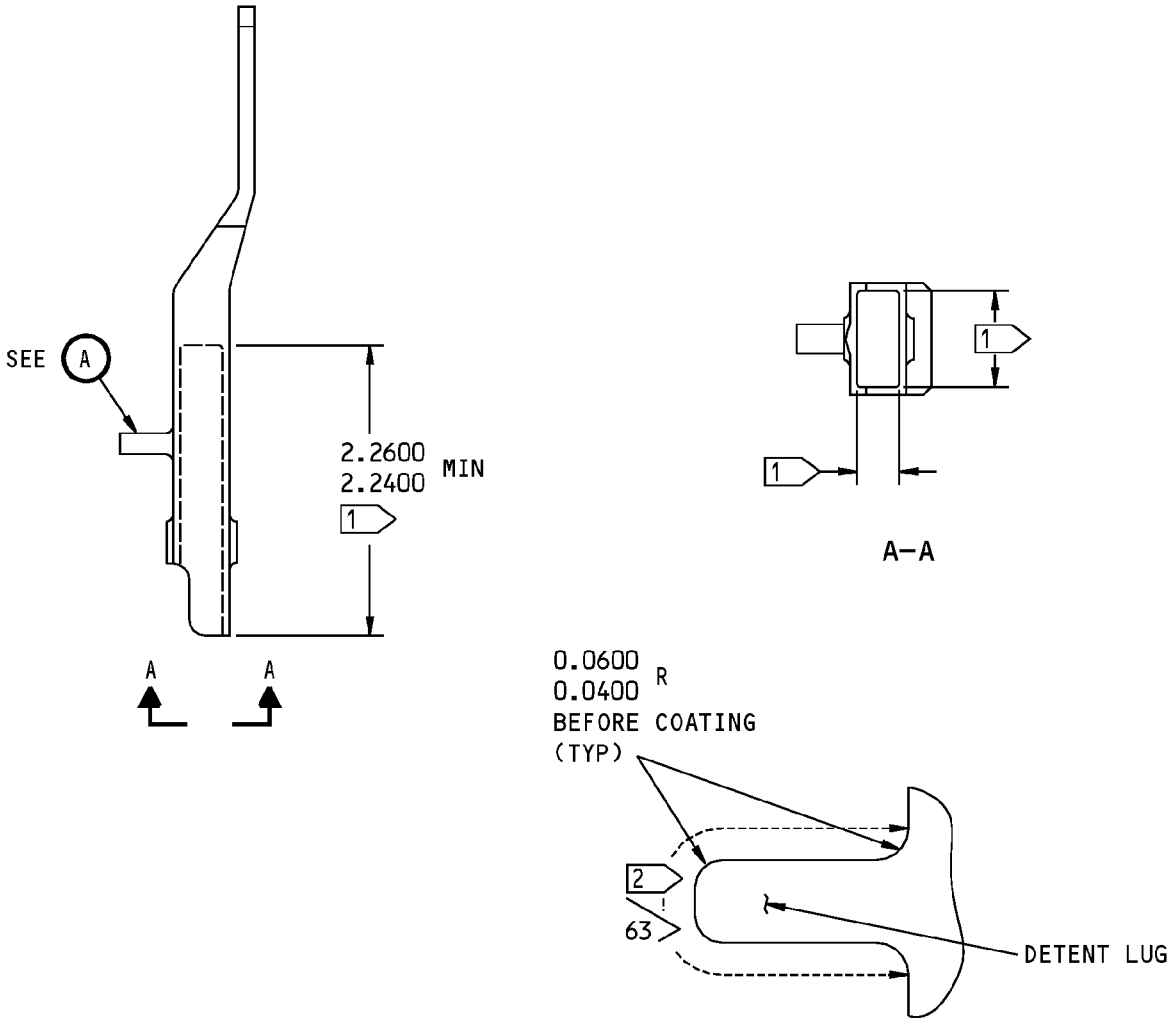
(2) Chrome plate (F-14.111) all over, except as shown in REPAIR 4-1, Figure 601.

(3) Shot peen the detent lug.

(4) Machine the detent lug as necessary to get a 63Ra or better finish on the detent lug surfaces.

(5) Apply a 0.003-0.005 inch thick layer of flame spray coating, G00167 (F-15.390) to all the surfaces of the detent lug, as shown in REPAIR 4-1, Figure 601, except do not grind. Finish the detent lug with a wire brush to a 125Ra surface finish. Use flame spray coating, G00167 for (F-15.390) finish.

(6) Apply lubricant, D00113 (F-19.10) to the inner surfaces of the handle (125) as shown in REPAIR 4-1, Figure 601.



1 DO NOT PLATE (F-14.111) THE INNER SURFACES OF THE HANDLE. APPLY BMS 3-8, TYPE 8 (F-19.10) TO THESE SURFACES

2 DO NOT PLATE (F-14.111) THE DETENT LUG. APPLY BMS 10-67, TYPE 1 LAYER (F-15.390) USING LW-3N40 POWDER. MAKE SURE THE THICKNESS OF THE LAYER IS 0.003-0.005 INCHES

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65-32189-13 Handle Repair
Figure 601

ASSEMBLY

1. General

A. This procedure has the data necessary to assemble the flap control handle assembly.

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to IPL Figure 1 for item numbers.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
G01505	Lockwire - Safety And Lock	NASM20995

B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For bolt and nut installation, refer to SOPM 20-50-01.For installation of safety devices, refer to SOPM 20-50-02. For miscellaneous materials, refer to SOPM 20-60-04.

(1) Attach the link assembly (25) to the drum assembly (55) with the bolt (5), washers (10, 15), and nut (20).

(2) Install the lever (105) onto the drum assembly (55) with bolts (40, 45) and collars (50).

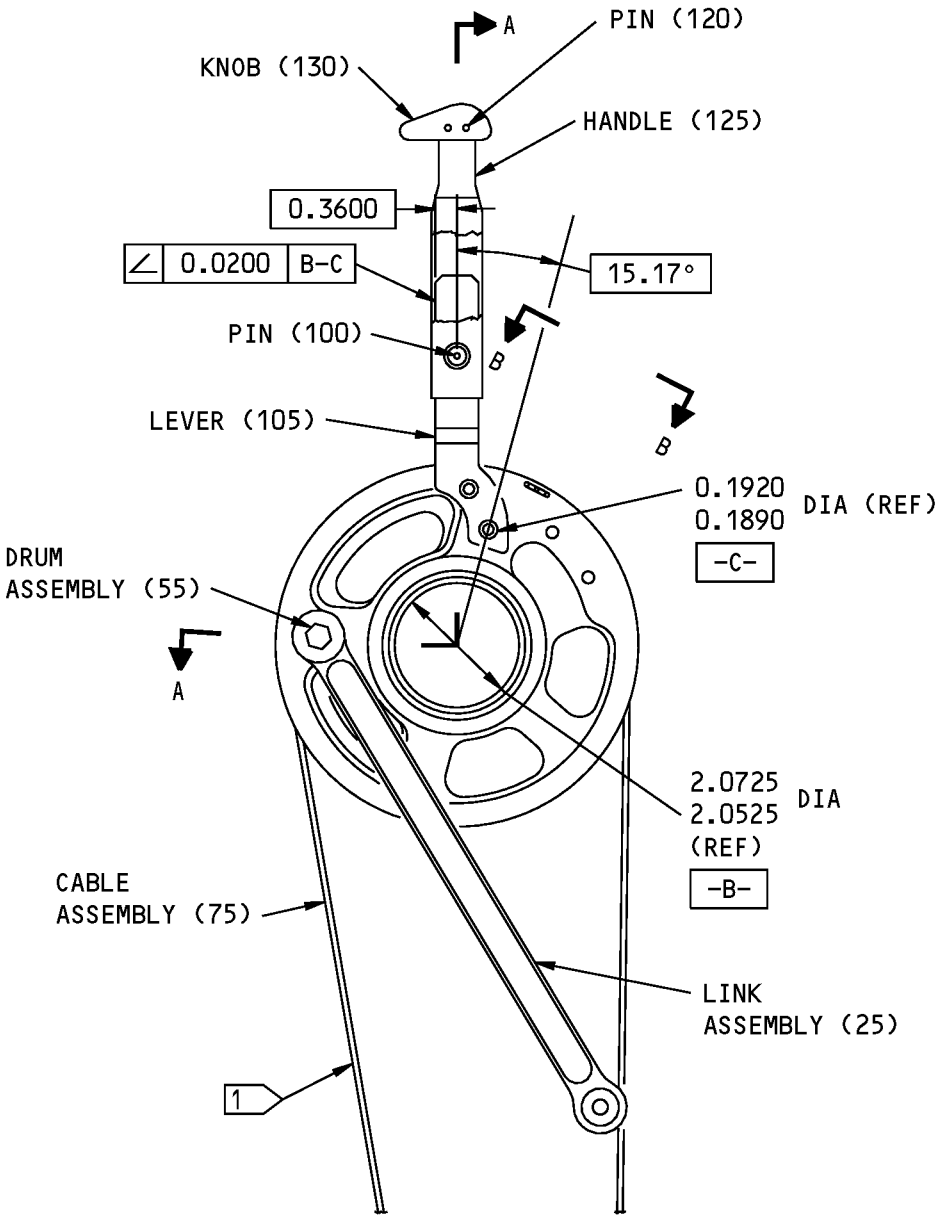
(3) Put the stop (110) and the spring (115) into the lever (105), then install the handle (125) onto the lever (105) as shown in ASSEMBLY, Figure 701.

(4) Install the pin (100) through the handle (125) and the stop (110). Make sure that the pin is centered.

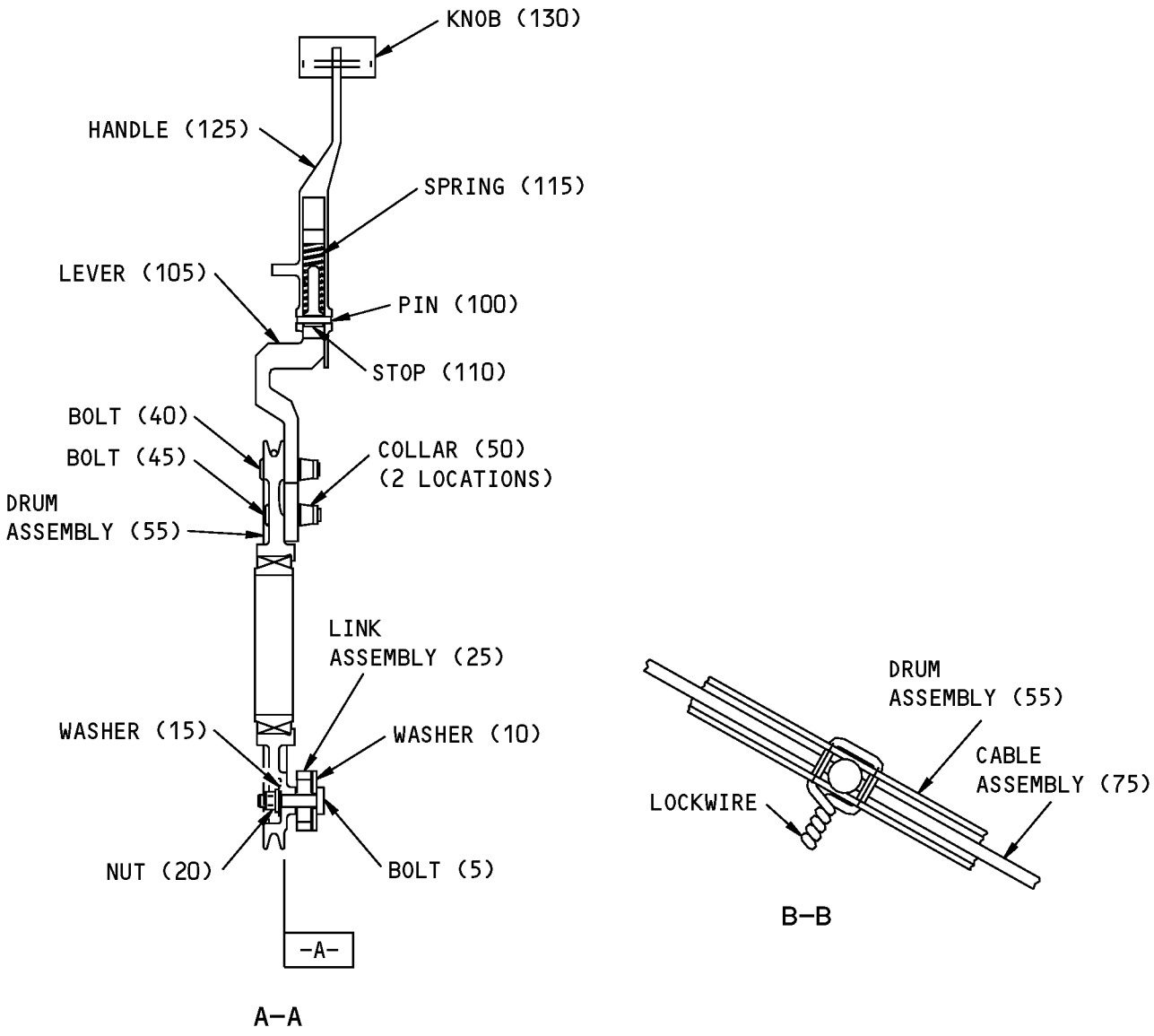
(5) Attach the knob (130) to the handle (125) with pin (120).

(6) Install the cable assembly (75) onto the drum assembly (55) and install lockwire, G01505lockwire as shown in ASSEMBLY, Figure 701. Make sure the twisted end of the lockwire does not go past the outer diameter of the drum assembly (55).

(7) Make sure the handle (125) does not stick or bind when you move it up and down on the lever (105).



Assembly Details
Figure 701 (Sheet 1 of 2)

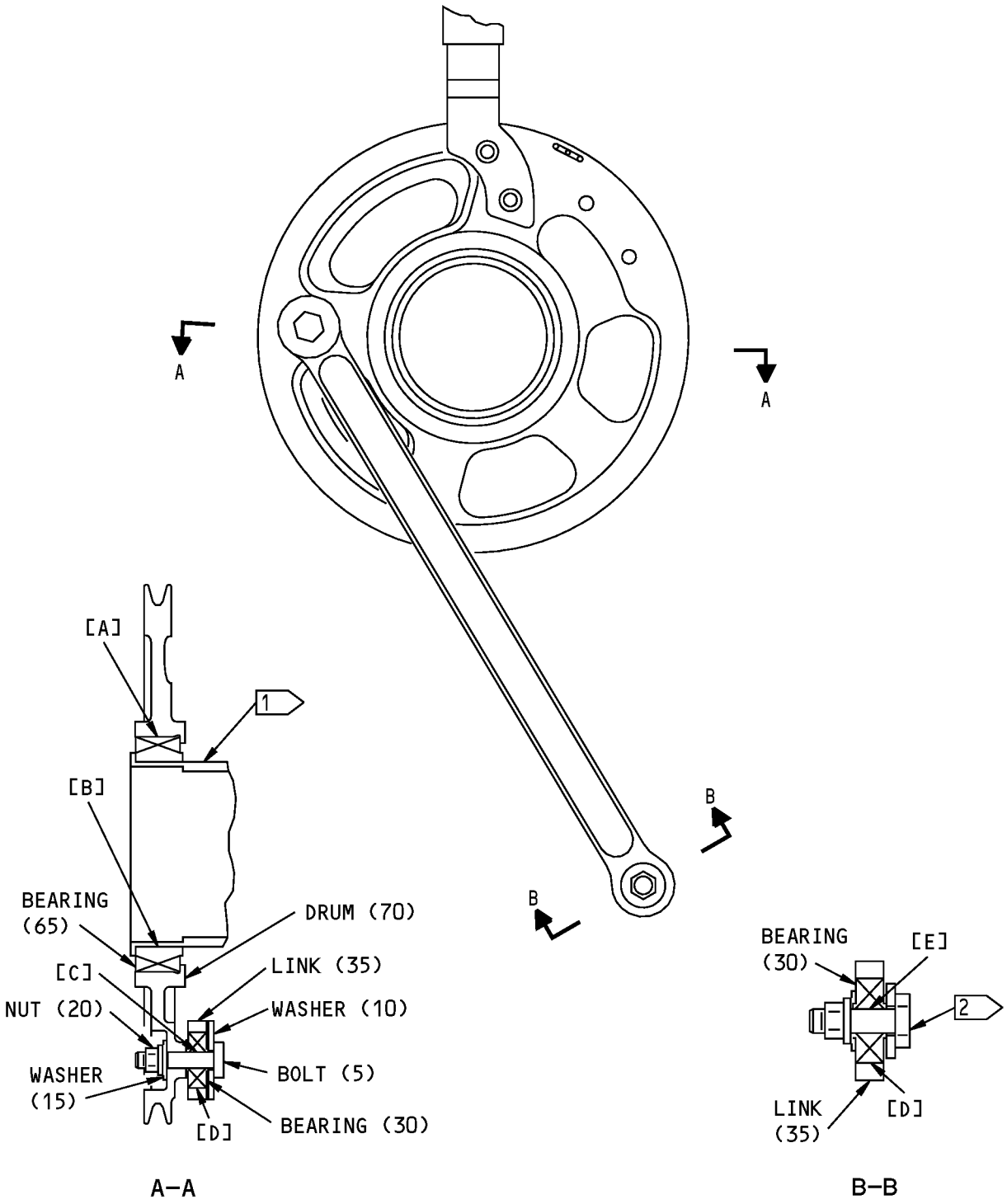


1 PUT THE LONG END OF THE CABLE ASSEMBLY HERE

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Assembly Details
Figure 701 (Sheet 2 of 2)



Fits and Clearances
Figure 801 (Sheet 1 of 2)

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
[A]		ID 70 OD 65	2.6155 2.6243	2.6355 2.6250	-0.0095	0.0112			
[B]		ID 65 OD 1	2.0617 2.0607	2.0625 2.0617	0.0000	0.0018			
[C]		ID 30 OD 5	0.1897 0.1885	0.1900 0.1895	0.0002	0.0015			
[D]		ID 35 OD 30	0.6238 0.6246	0.6243 0.6250	-0.0012	-0.0003			
[E]		ID 30 OD 2	0.1897 0.1885	0.1900 0.1895	0.0002	0.0015			
[F]		ID OD							
[G]		ID OD							
[H]		ID OD							

* ALL DIMENSIONS ARE IN INCHES

1 NEXT HIGHER ASSEMBLY SHAFT
254A1227-1

2 NEXT HIGHER ASSEMBLY BOLT
BACB30VT6K5

Fits and Clearances
Figure 801 (Sheet 2 of 2)

(NOT APPLICABLE)

ILLUSTRATED PARTS LIST

1. Introduction

A. The Illustrated Parts List (IPL) contains an illustration and a list of component parts you can repair or replace. The Illustrated Parts Catalog (IPC) shows how to use the Boeing part number system.

B. This shows how parts are related: The relation of each item to its next higher assembly (NHA) is shown in the NOMENCLATURE column. Use the indenture system that follows:

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

Detail Installation Parts (Included only if installation parts may be sent to the shop as part of assembly)

C. Each top assembly is given one use code letter (A, B, C, etc.) in the USAGE CODE column. All subsequent component parts in the list can have one or more of the use code letters to show effectivity to top assemblies. A component part without a use code applies to all top assemblies.

D. An alphabetical letter is added after the item number for optional parts, parts changed by a Service Bulletin, configuration differences (except left-handed and right-handed parts), last engineering releases, and parts added between item numbers in a sequence. The alphabetical letter will not be shown on the illustration for equivalent parts of the same part number.

E. Color-coded parts are identified with a single digit alpha following the dash number or with ''SP'' suffix. If the ''SP'' suffix is used, it represents consolidation of all color codes applicable for a given usage which are not separately listed. Orders for color-coded parts should include the registry number of the airplane for which the parts are ordered.

F. If a part number is 15 characters long but will not fit in the part number column, the part number will be displayed with a ''~'' at the end of the line and will be continued on the next line. The ''~'' denotes that the part number continues on the next line.

G. Parts changed by a Service Bulletin are shown by PRE SB XXXX and POST SB XXXX added to the NOMENCLATURE column.

(1) When a new top assembly is added by a Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the top assembly level only. The configuration differences at the detail part level are shown by use code letters.

(2) When the top assembly part number is not changed by the Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the detail level.

H. Interchangeable Parts

Optional (OPT)	The part is optional to and interchangeable with other parts that have the same item number.
Replaces, Replaced by and not interchangeable with (REPLACES, REPLACED BY AND NOT INTCHG/W)	The part replaces and is not interchangeable with the initial part.
Replaces, Replaced by (REPLACES, REPLACED BY)	The part replaces and is interchangeable with, or is an alternative to, the initial part.

VENDOR CODES

Code	Name
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
21335	TIMKEN US CORPORATION DIV FAFNIR 336 MECHANIC STREET LEBANON, NH 03766-0267 FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN NEW BRITAIN, CONNECTICUT ; FORMERLY TORRINGTON CO THE SPECIAL PRODUCTS DIV SUB OF THE INGERSOLL-RAND CO V8D210 FORMERLY TORRINGTON CO FAFNIR BEARING DIV IN TORRINGTON, CT
22277	BELL-MEMPHIS INC 1650 CHANNEL AVENUE MEMPHIS, TENNESSEE 38113-0187 FORMERLY BELL,R.E. MFG CO V11097

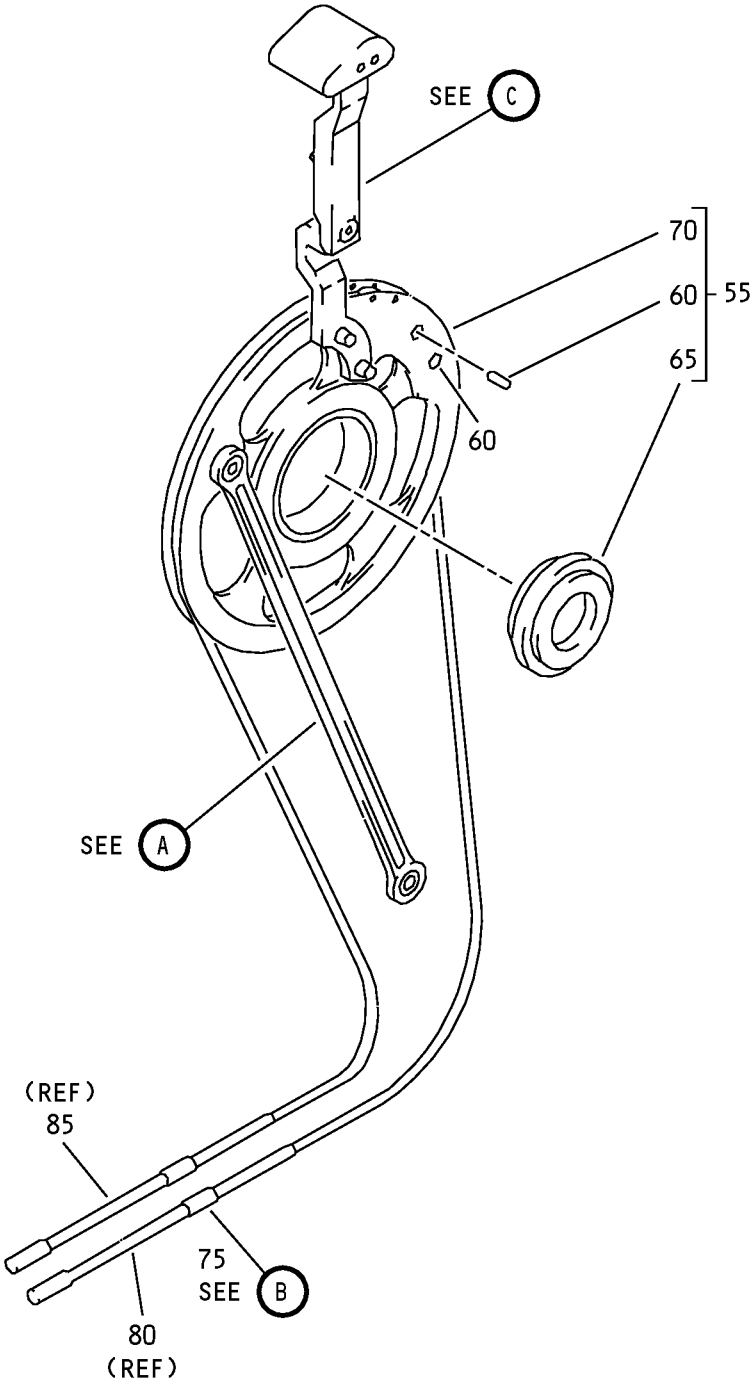
Code	Name
26590	HOOD INDUSTRIES 4615 SHEPARD STREET BAKERSFIELD, CALIFORNIA 93309 FORMERLY IN PARAMOUNT, CALIFORNIA
40920	MPB MINIATURE PRECISION BEARING DIV PRECISION PARK PO BOX 547 KEENE, NEW HAMPSHIRE 03431 FORMERLY MPB CORP AND MINIATURE BRG DIV MPB CORP
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
65196	CABLEWARE TECHNOLOGY INC 900 INDUSTRIAL BLVD. PO BOX 7515 NAPLES, FLORIDA 33941
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
80523	BABCOCK ACCO INC ACCO CONTROLS GROUP SUB OF BABCOCK INTL 1014 ERIE STREET PO BOX 608 ADRIAN, MICHIGAN 49221-0608 FORMERLY CABLE CONTROLS DIV OF AMERICAN CHAIN AND CABLE FORMERLY ACCO IND INC CABLE CONTROLS DIV

Code	Name
83014	HARTWELL CORPORATION 900 SOUTH RICHFIELD ROAD PLACENTIA, CALIFORNIA 92670-6732 FORMERLY V0532B IN LOS ANGELES, CALIFORNIA
83086	NEW HAMPSHIRE BALL BEARING, INC HITECH DIVISION 172 JAFFREY ROAD PETERBOROUGH, NEW HAMPSHIRE 03458
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF

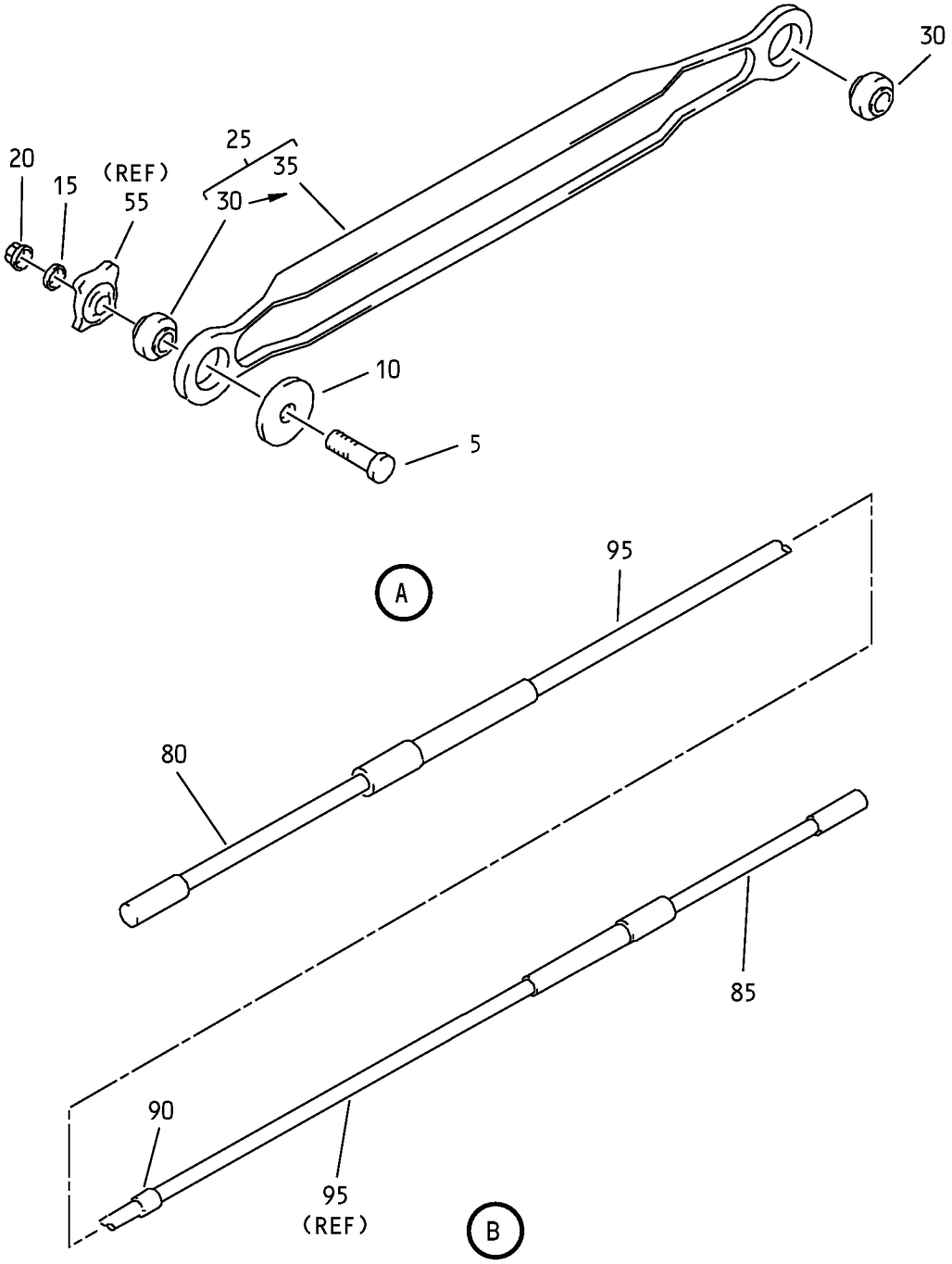
NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
254A1260-1		1	1A	RF
254A1260-2		1	1B	RF
254A1261-3		1	55	1
254A1261-4		1	70	1
254A1263-1		1	105	1
254A1264-1		1	25	1
254A1264-2		1	35	1
254A1265-1		1	75	1
254A1265-2		1	95	1
254A1265-3		1	75A	1
254A1265-4		1	95A	1
65-32189-13		1	125	1
65C14183-33		1	130	1
66-14222-2		1	110	1
66-21426-1		1	115	1
ACB5545WZZ		1	65	1
ACMB5545WZZLY198		1	65	1
AN970-3		1	10	1
B5545WZZFS428		1	65A	1
BA3-3		1	90	1
BACB10FP3LJ		1	30	2
BACB10GG33		1	65	1
BACB30NM3K8		1	5	1
BACB30VT6K7		1	45	1
BACB30VT6K8		1	40	1
BACC30BL6		1	50	2
BACN10YR3CD		1	20	1
BACT14B3		1	90	1
BM2487-3		1	90	1
H52732-3CD		1	20	1
HI2487-3		1	90	1
HST10AG6-7		1	45	1
		1	45	1
		1	45	1

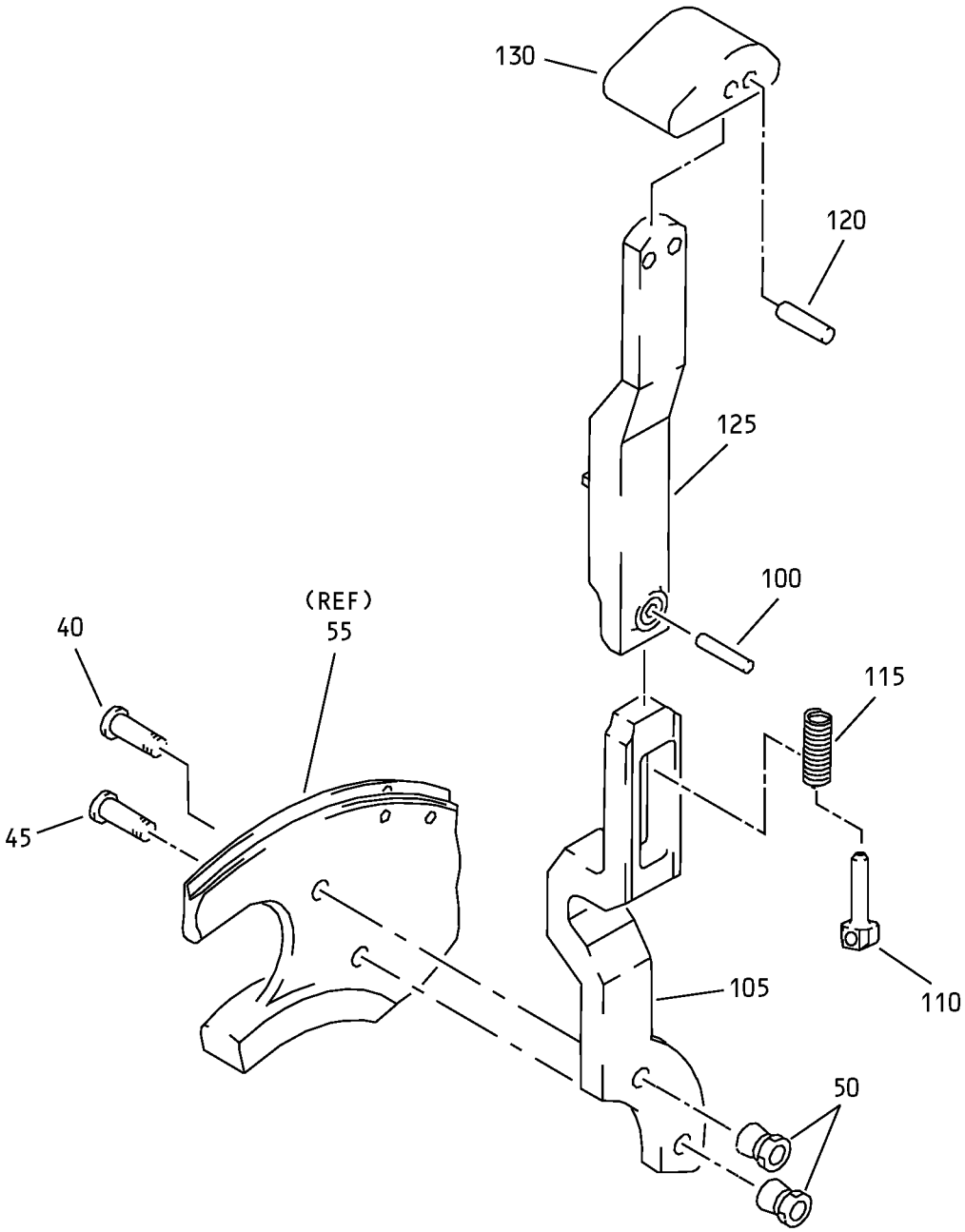
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	45	1
HST10AG6-8		1	40	1
		1	40	1
		1	40	1
		1	40	1
HST79-6		1	50	2
		1	50	2
		1	50	2
		1	50	2
HT200-3		1	90	1
MS21209F1-10P		1	60	2
MS21260L3LH		1	80	1
MS21260L3RH		1	85	1
MS39086-31		1	100	1
MS39086-37		1	120	2
NAS1149E0316P		1	15	1
PLH53CD		1	20	1
RA2487-3		1	90	1
SSB5545WZZSD703G		1	65	1
SSMKSP3LGSD705		1	30	2



Control Stand Flap Control Handle Assembly
IPL Figure 1 (Sheet 1 of 3)



Control Stand Flap Control Handle Assembly
IPL Figure 1 (Sheet 2 of 3)



Control Stand Flap Control Handle Assembly
IPL Figure 1 (Sheet 3 of 3)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
1A	254A1260-1		HANDLE ASSY-FLAP CONT	A	RF
–1B	254A1260-2		HANDLE ASSY-FLAP CONT	B	RF
5	BACB30NM3K8		. BOLT		1
10	AN970-3		. WASHER		1
15	NAS1149E0316P		. WASHER		1
20	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		1
25	254A1264-1		. LINK ASSY		1
30	SSMKSP3LGSD705		. . BEARING (V83086) (SPEC BACB10FP3LJ)		2
35	254A1264-2		. . LINK		1
40	HST10AG6-8		. BOLT (V0PTK6) (SPEC BACB30VT6K8) (OPT HST10AG6-8 (V06725)) (OPT HST10AG6-8 (V56878)) (OPT HST10AG6-8 (V73197))		1
45	HST10AG6-7		. BOLT (V0PTK6) (SPEC BACB30VT6K7) (OPT HST10AG6-7 (V06725)) (OPT HST10AG6-7 (V56878)) (OPT HST10AG6-7 (V73197))		1
50	HST79-6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		2
55	254A1261-3		. DRUM ASSY		1
60	MS21209F1-10P		. . INSERT		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
65	ACB5545WZZ		. . BEARING (V21335) (SPEC BACB10GG33) (OPT ACMB5545WZZLY198 (V40920)) (OPT SSB5545WZZSD703G (V83086)) (OPT ITEM 65A)		1
–65A	B5545WZZFS428		. . BEARING (OPT ITEM 65)		1
70	254A1261-4		. . DRUM		1
75	254A1265-1		. CABLE ASSY	A	1
–75A	254A1265-3		. CABLE ASSY	B	1
80	MS21260L3LH		. . TERMINAL		1
85	MS21260L3RH		. . TERMINAL		1
90	BA3-3		. . TERMINAL (V65196) (SPEC BACT14B3) (OPT HI2487-3 (V26590)) (OPT HT200-3 (V83014)) (OPT RA2487-3 (V80523)) (OPT BM2487-3 (V22277))		1
95	254A1265-2		. . CABLE	A	1
–95A	254A1265-4		. . CABLE	B	1
100	MS39086-31		. PIN-SPRING		1
105	254A1263-1		. LEVER		1
110	66-14222-2		. STOP		1
115	66-21426-1		. SPRING-CPRSN		1
120	MS39086-37		. PIN-SPRING		2
125	65-32189-13		. HANDLE		1
130	65C14183-33		. KNOB		1

–Item not Illustrated